

Work Order ID 146919

Tuesday, June 07, 2016 9:04:57 AM

146919

Page 1

Item ID: D4151-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Hardpoint Plate

Start Date: 6/21/2016 Start Qty: 10.00

10

Cust Item ID:

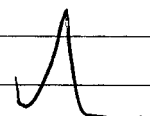
Required Date: 6/23/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4151

C

105

0.00

105

Purchasing

Purchasing

6.00

Memo

ISSUE PO 32646
CUT PER DRWG D4151 REV.C

0.00

10 JUN 08 2016

DAS
13
9-89

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

10X SP/6-6-21

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

(10)

DAS
38
JUN 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Tuesday, June 07, 2016 9:04:57 AM

Page 1

Work Order ID: 146919

146919

Parent Item: D4151-3

D4151-3

Parent Item Name: Upper Hardpoint Plate

Start Date: 6/21/2016

Required Date: 6/23/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-3P		Purchased	No				Each	0.0000		10			
D4151-3P									**				
Upper Hardpoint Plate													
M304S11GA		Purchased	No			100	sf	107.2349	0.055	0.578947			
M304S11GA									**				
304/316 0.125 Sheet													

10x SP/6-6-21

JUN 24 2016

DAS
13
9-89

Location	Loc Qty	Loc Code
MAT020	80.99998	
M129545	31.99998	
M129972	23.5	
M134284	25.5	
TPI	26.234932	
M134604	26.234932	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

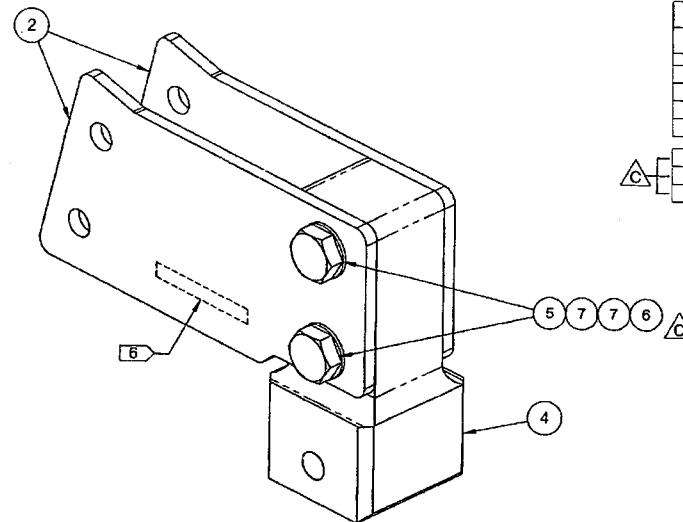
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

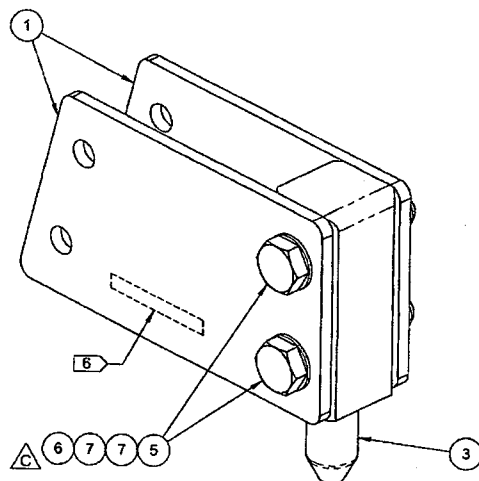
FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	38	Audited by:	PD	Preliminary Approval:	
Date:	JUN 22 2016	Date:	1606-24	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	11.01.28	Dimensions updated per Dwg Rev C	KJ	



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

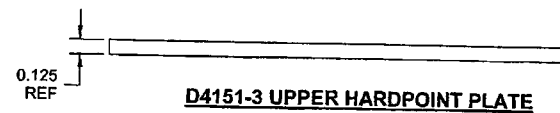
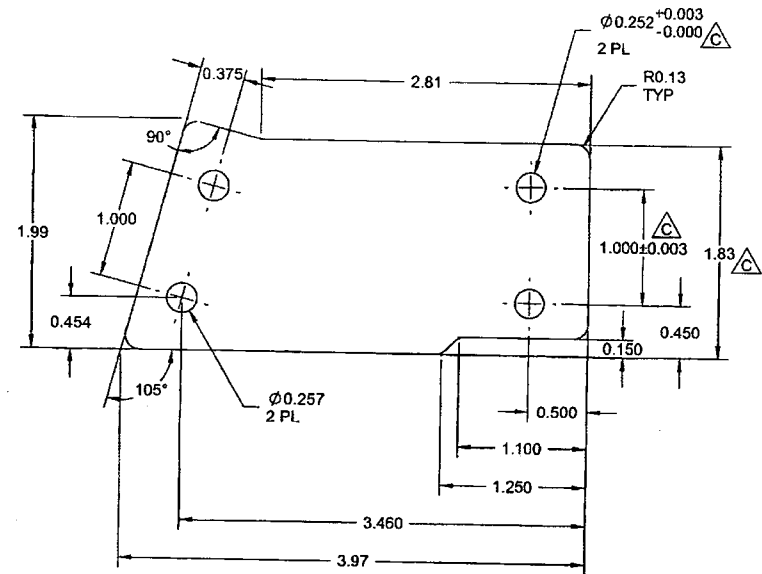
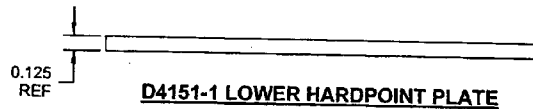
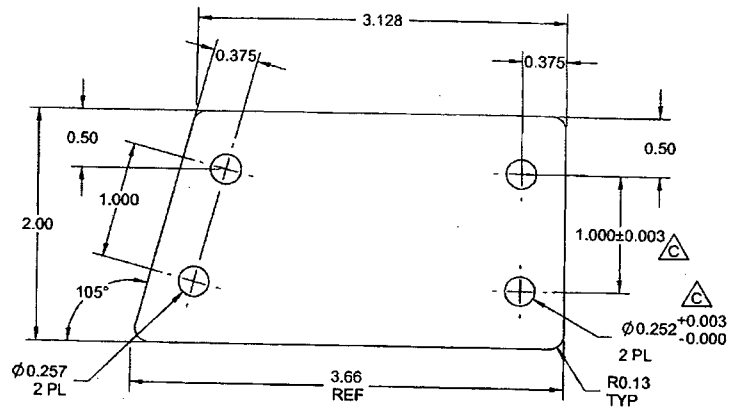
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 146919 u/s
16-05-26

RELEASED
R 2011-01-28

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.76 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-787 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.08.22
REV.	DESCRIPTION	BY	DATE
DESIGN	1 2 SC 10/15 11	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV.
CHECKED		D4151	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET FWD HARDPOINT	NT
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. HAS A SUPPLEMENTAL RELEASE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE		10.12.14	

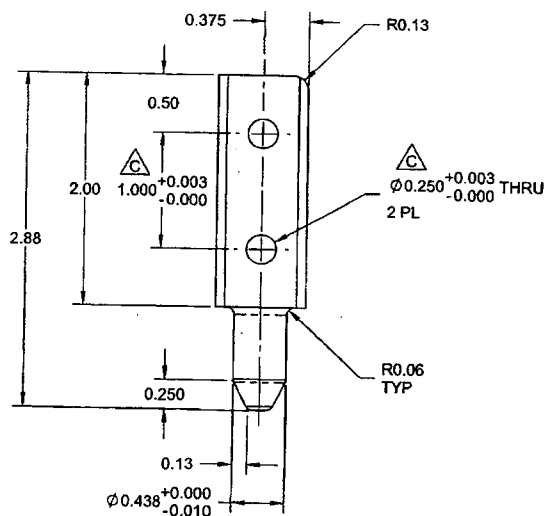
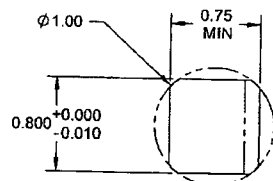
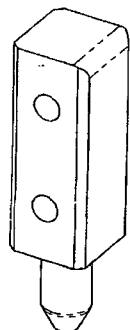


NOTES:

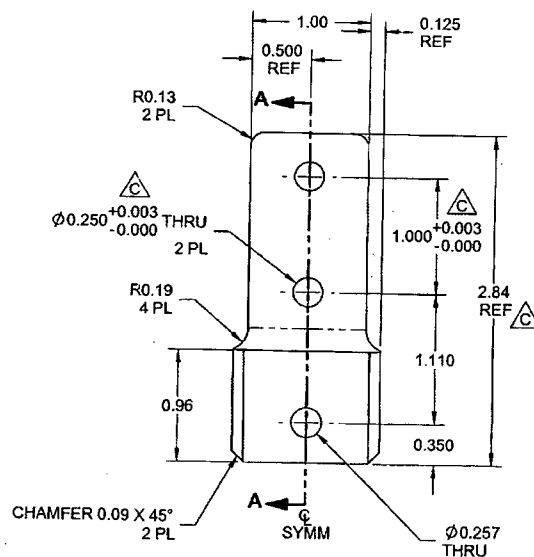
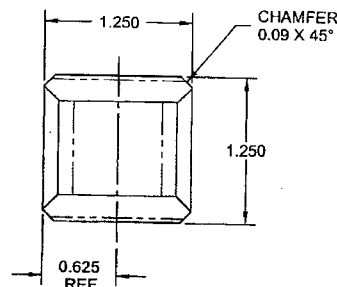
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
 - D4151-1 = 0.24 lbs
 - D4151-3 = 0.23 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

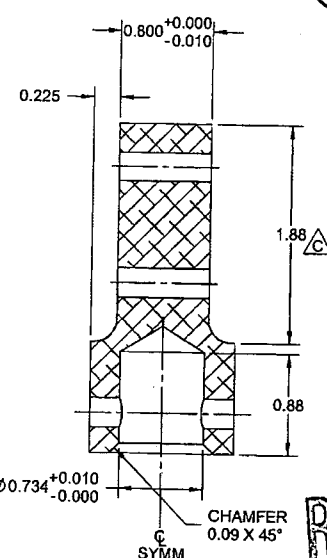
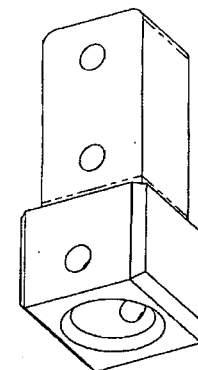
RELEASED
2011-01-18



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2011-01-03
RELEASED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32646

Purchase Order Date 6/8/2016

PO Print Date 6/8/2016

Page Number 11 of 12

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

10127-2607

Net 30

CAD

Destination-Collect

27	D4149-1P	Crosstube Lug Plate, Aft	6/22/2016	FN	12.00	\$14.75	\$177.00
			Yes		Each		
			6/22/2016				

CUT AS PER DWG D4149 REV. C
B145911
MATERIAL 304 SHEET 11GA

Line Total: \$177.00

28	D4151-1P	Lower Hardpoint Plate	6/22/2016	FN	10.00	\$5.95	\$59.50
			Yes		Each		
			6/22/2016				

CUT AS PER DWG D4151 REV. C
B146963
MATERIAL 304 SHEET 11GA

Line Total: \$59.50

29	D4151-3P	Upper Hardpoint Plate	6/22/2016	FN	10.00	\$6.00	\$60.00
			Yes		Each		
			6/22/2016				

CUT AS PER DWG D4151 REV. C
B146919
MATERIAL 304 SHEET 11GA

Note:

6/8/2016

SP/6-6-21

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.:

7618

Date:

2016-06-17

Page:

1

Sold to:		Ship to:	
Dart Aerospace Chantal Lavoie 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada		Dart Aerospace Chantal Lavoie 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	
Order No.: 32646		Sold By: JONATHAN LESSARD	
Shipped By:		Ship Date:	
Tracking No.:			

Item No.	Unit	Description	Quantity
d3405-1 ✓	Chaque	d3405-1 ✓	✓24
d3405-3 ✓	Chaque	d3405-3 ✓	✓20
d3912-5 ✓	Chaque	d3912-5 eyebolt plate	✓24
d4150-3	Chaque	d4150-3 arm plate	24
d4149-1	Chaque	d4149-1 crosstube lug plate aft	32
d2581	Chaque	d2581 mounting bracket	60
d4151-1	Chaque	d4151-1 lower hardpoint plate	10
d4151-3	Chaque	d4151-3 upper hardpoint plate	10

Sp/6-6-21

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days

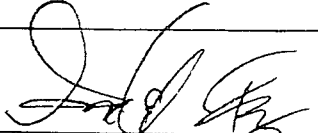
TPI Waterjet cutting follow up sheet

WC100127

machine hours	1162h
diamond hours	112h
mixing tube hours	0h
TAJ calibration	13-06-2016

customer po	part #	Qty	lot #	date done	cut by	quality spot check	Note
dart 32646	D3405-1	24	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D3405-3	20	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D3912-5	24	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D4150-3	24	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D4149-1	32	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	test approve by Eric Downing change hole size of .252 to .25
dart 32646	D2581	60	see mill test	15-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D4151-1	10	see mill test	15-06-2016	GR	Jonathan Lessard Gabriel Rioux	test approve by Eric Downing change hole size of .252 to .25
dart 32646	D4151-3	10	see mill test	15-06-2016	GR	Jonathan Lessard Gabriel Rioux	change hole size of .252 to .25

Opérateur



Superviseur

